

# Work Order ID 82683

\*82683\*

Page 1

April-04-12 1:58:08 PM

Item ID: D350-636-012

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 04/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/05 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750	F								
D3492	C								

100

\*100\*

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

0.00

0.00

W/H 12.05.10

NON  
HIFORMS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 82683****\*82683\***

Page 2

April-04-12 1:58:08 PM

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 04/04/2012 Start Qty: 1.00

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Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00

**\*110\***

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1- Pick D2600-3 Bent ✓

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750 ✓

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr. ✓

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting ✓

5- Drill only two fwd step holes using DT9616. Ensure proper positioning. ✓

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 &amp; DT8863A for first side only DT8863B for second side (detail K) ✓

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. \*\*\*SECOND SIDE\*\*\* ✓

8- Open up holes for Detail "K" to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side) ✓

9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". ✓

10- Open up holes of Detail A to 0.297" (total of 2 holes per side) ✓

12-04-23

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Page 3

April-04-12 1:58:08 PM

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Revision ID:

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Item Name: Skidtube RH

Start Date: 04/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004A/R Aluminum Rod batch: *m120854* *86* *12/04/23*12-Grind welds flush as per Dwg D2750 *86* *12-04-23*

120

QC10- Inspect visual per QSI004- ground welds

0.00

**\*120\***

QC

Memo

0.00 *8.12/ku/24*

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00 *8.12/ku/24*

Quality Control

W/O:		WORK ORDER CHANGES					
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Page 4

April-04-12 1:58:08 PM

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Item Name: Skidtube RH

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\*1\*

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140 Chemical Conversion Coat per QSI005 4.1

0.00

\*140\*

HandFinish

Memo

0.00

Hand Finishing

1 0 CF 12424

150 QC7-Inspect Chemical Conversion Coat

0.00

\*150\*

QC

Memo

0.00

Quality Control

(1) SAD 120425

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Page 5

April-04-12 1:58:08 PM

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Item Name: Skidtube RH

Start Date: 04/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
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Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00

**\*160\***

Skidtubes

0.00

Skidtubes

**Memo**

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: m121221  
exp. date: 13-1-4

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 &amp; QSI004 (welding instructions on sheet 9)

A/R Aluminum Rod

batch: m120854

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

1 CF 12-4-2612-5-2  
12-5-02  
12-5-2

W/O:		WORK ORDER CHANGES					
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\*82683\*

Page 6

April-04-12 1:58:08 PM

Item ID: D350-636-012

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Skidtube RH

Stop \*NS2\*

Start Date: 04/04/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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dwg D2750

12-Deburr holes

*[Handwritten signature]* / CC 12-5-2

170 QC10- Inspect visual per QSI004- ground welds 0.00

\*170\*

QC Memo 0.00

Quality Control

*5/12/12*

180 QC5- Inspect part completeness to step on W/O 0.00

\*180\*

QC Memo 0.00

Quality Control

*5/12/12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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\*82683\*

Page 7

April-04-12 1:58:08 PM

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 04/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Run Start \*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Pressure Wash per QSI005 4.3

0.00

\*190\*

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

76 12-5-2

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

\*200\*

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:20  
320°F  
3:50

1X 12/05/02

210

QC3- Inspect Part Finish

0.00

\*210\*

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

1 RH 12/05/03

m121134

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 8

April-04-12 1:58:08 PM

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Item Name: Skidtube RH

Start Date: 04/04/2012 Start Qty: 1.00 \*1\*

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Required Date: 18/04/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230

0.00

\*230\*

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts as per dwg D2750

2-Inspect for Foreign Objects

3-Spray inside of tube with "LPS-3"  
batch: 01A

4-Install blade fitting D3488-042, wearshoes and ground handling hardware as  
per dwg D2750  
SIKA FLEX 241  
BATCH: AA 121221  
EXP DATE: 13101

5-assemble o'ring to plug as per dwg D3492 and apply o'ring lube  
A/R 55-o'ring lube batch: AA110340

6-Coat all exposed fasteners with "LPS Procyon"  
batch: AA1114596

1 Btl 6 all n/oz (03)

W/O:		WORK ORDER CHANGES					
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\*82683\*

Page 9

April-04-12 1:58:08 PM

Item ID: D350-636-012

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Setup Start \*NS1\*

Revision ID:

Item Name: Skidtube RH

Stop \*NS2\*

Start Date: 04/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
*240*		0.00							
QC	Memo								
Quality Control									
250	Pick Kit	0.00							
*250*		0.00							
Packaging	Memo								
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
*260*		0.00							
QC	Memo								
Quality Control									

12/5/10

12-05-10

W/O:		WORK ORDER CHANGES					
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\*82683\*

Page 10

April-04-12 1:58:08 PM

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\*N9000040100\*

Setup Start

\*NS1\*

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Item Name: Skidtube RH

Stop

\*NS2\*

Start Date: 04/04/2012 Start Qty: 1.00

\*1\*

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\*1\*

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Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
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Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

270

0.00

\*270\*

Packaging

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012

Rev I

280

0.00

\*280\*

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

R

12-5-10

12/5/10

MS 12/05/10

82683

W/O:		WORK ORDER CHANGES					
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## .. Picklist Print

April-04-12 1:58:12 PM

Page 1

**Work Order ID:** 82683

**\*82683\***

**Parent Item:** D350-636-012

**\*D350-636-012\***

**Parent Item Name:** Skidtube RH

**Start Date:** 04/04/2012**Required Date:** 18/04/2012

**Start Qty: 1.00**

**Required Qty: 1.00**

**Comments:**

IPP Rev:102.09.25Rearranged procedure stepsK.J

IPP Rev:J 06-03-29 As per Rev D EC

IPP Rev:K 06-07.13 As per dsi9343 EC

IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC

IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O

10.06.22 revise seq110 DD verf:EC

IPP Rev:P 10.10.01 as

per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	15.0000	1	1			
*D2600-3-BFNT*				B 83305					**	(1)		12-04-20	
Extrusion Bent													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				15					
				66875				7					
				73253				1					
				75021				1					
				75022				1					
				75023				1					
				81330				4					
D2744		Manufactured	No			110	Each	46.0000	1	1			
*D2744*									**			BE 12/01/23	
Cap													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG002				46					
				62715				1					
				70881				3					
				78900				42					

W/O:		WORK ORDER CHANGES					
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April-04-12 1:58:12 PM

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Parent Item Name: Skidtube RH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160 Each

5.0000

1

1

\*D2739\*

350 I Beam.

\*\*

① CF 12-4-25

Location

Loc Qty

Loc Code

LG

5

72155

1

81508

1

82122

3

D2743

Manufactured No

160 Each

346.0000

8

8

\*D2743\*

Crossbolt Spacer

\*\*

BE 12-05-01  
B81965 x 8

Location

Loc Qty

Loc Code

LG001

346

67766

4

68251

3

73403

64

74445

1

78603

2

79517

62

D3490-3

Manufactured No

160 Each

90.0000

4

4

\*D3490-3\*

Cross Bolt Spacer

\*\*

BE 12/05/01  
B B3313 x 2

Location

Loc Qty

Loc Code

LG

88

82016

88

LG001

2

78800

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

April-04-12 1:58:12 PM

Work Order ID: 82683

\*82683\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160 Each

124.0000 4 4

\*D3490-1\*

Cross Bolt Spacer

\*\*

BE 12/05/01

Location

Loc Qty

Loc Code

LG

115

81976

115

LG001

9

62450

2

74875

4

77042

3

D3631-1

Manufactured No

230 Each

243.0000 8 8

\*D3631-1\*

Washer

\*\*

YL 12/05/03

Location

Loc Qty

Loc Code

FG

100

81874

100

ST072

143

68062

2

75548

141

D3791-1

Manufactured No

230 Each

9.0000 1 1

\*D3791-1\*

Wearplate

\*\*

YL 12/05/03

Location

Loc Qty

Loc Code

FP002

9

62239

2

78897

7

B83392

Y1

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 4

April-04-12 1:58:12 PM

Work Order ID: 82683

\*82683\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230 Each

30.0000

1 1

\*D3793-3\*

Wearshoe

\*\*

yl 12/05/03

## Location

## Loc Qty

## Loc Code

FP001

23

80434

11

82166

12

FP002

7

78935

7

MS21043-6

Purchased No

230 Each

773.0000

4 4

\*MS21043-6\*

NUT

\*\*

yl 12/05/03

## Location

## Loc Qty

## Loc Code

FG

20

103693

20

ST301

753

112314

47

117887

6

118384

200

120308

500

D3794-1

Manufactured No

230 Each

16.0000

1 1

\*D3794-1\*

Gasket

\*\*

yl 12/05/03

## Location

## Loc Qty

## Loc Code

FP002

16

75042

4

80435

12

1382167

yl

April-04-12 1:58:12 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 5

April-04-12 1:58:12 PM

Work Order ID: 82683

**\*82683\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

275.0000

8

8

**\*NAS1611-010\***

O-RING

\*\*

21 12/05/03

Location

Loc Qty

Loc Code

FP

50

11121415

X7

110915

0

120770

50

FP001

225

110915

14

117460

8

118077

1

118612

3

119438

47

120986

50

121166

52

121259

50

X1

D2741

Manufactured

No

250

Each

67.0000

1

1

**\*D2741\***

Blade, 350 Skidtube

\*\*

12/5/88

Location

Loc Qty

Loc Code

ST

-10

ST466

77

71856

1

76984

26

79516

40

1

April-04-12 1:58:12 PM

Shop Packet Print

Page 5

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

April-04-12 1:58:12 PM

Work Order ID: 82683

**\*82683\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

198.0000

4

4

**\*NAS1515H3I \***

WASHER

\*\*

JA 12/05/03

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

158

118686

3

119438

1

120072

8

120360

96

121243

50

XC1

NAS1611-013

Purchased

No

230

Each

250.0000

8

8

**\*NAS1611-013\***

O-RING

\*\*

JA 12/05/03

Location

Loc Qty

Loc Code

FP001

250

116582

5

117291

2

117887

53

119623

36

120910

4

121166

100

121259

50

11121584

XC8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

Page 7

April-04-12 1:58:12 PM

Work Order ID: 82683

\*82683\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

517.0000

4

4

\*AN3C6A\*

BOLT

\*\*

HL 12/05/03

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

516

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

27

120693

400

HL

NAS1149C0832R

Purchased

No

230

Each

295.0000

1

1

\*NAS1149C0832R\*

WASHER

\*\*

HL 12/05/03

Location

Loc Qty

Loc Code

ST297

295

114915

295

HL

D3536-25

Manufactured

No

230

Each

22.0000

1

1

\*D3536-25\*

Gasket

\*\*

HL 12/05/03

Location

Loc Qty

Loc Code

FP

14

81342

14

FP002

8

78902

8

HL

B83391

April-04-12 1:58:12 PM

Shop Packet Print

Page 7

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Picklist Print

Page 8

April-04-12 1:58:12 PM

Work Order ID: 82683

\*82683\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

23.0000

1

1

\*D3794-3\*

\*\*

Gasket

JL 12/05/03

LocationLoc QtyLoc Code

FP002

23

B83396

x1

74530

2

80436

21

AN3C5A

Purchased No

230

Each

1,602.000

34

34

\*AN3C5A\*

\*\*

Bolt

JL 12/05/03

LocationLoc QtyLoc Code

FP001

7

115835

7

ST350

1595

11121068

x34

116419

28

117343

13

117764

7

117872

2

119749

23

120423

522

1210168

500

121255

500

D3537-1

Manufactured No

230

Each

26.0000

3

3

\*D3537-1\*

\*\*

Wearpad

JL 12/05/03

LocationLoc QtyLoc Code

FG

10

B81959

x3

79833

10

FP002

16

69817

5

80337

11

April-04-12 1:58:12 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 9

April-04-12 1:58:12 PM

Work Order ID: 82683

**\*82683\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

22.0000

1

1

**\*D3535-25\***

Wearshoe

\*\*

41 12/05/03

## Location

## Loc Qty

## Loc Code

FP001

22

B82156

62233

1

80331

10

81357

11

D3492-3

Manufactured No

230

Each

1.0000

8

8

**\*D3492-3\***

Plug

\*\*

41 12/05/03

## Location

## Loc Qty

## Loc Code

FP-A

1

B83099

78600

1

AN960C10L

NAS1149C0332  
R

Purchased

No

230

Each

0.0000

38

38

**\*AN960C10I \***

washer

1121509

\*\*

(x38) 41 12/05/03

D3488-042

Manufactured No

230

Each

16.0000

1

1

**\*D3488-042\***

Blade Fitting Assembly, RH

\*\*

41 12/05/03

## Location

## Loc Qty

## Loc Code

FP002

16

62003

1

75068

8

77015

7

B82258

41

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April-04-12 1:58:12 PM

Work Order ID: 82683

**\*82683\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

2,477.000

38

38

**\*AI S4-1032-225\***

Insert

\*\*

yl 12/05/03

Location

Loc Qty

Loc Code

ST281

2454

108696

146

110768

62

118386

55

118966

68

120671

123

121269

2000

y38

ST282

23

120410

10

120451

13

D3492-1

Manufactured

No

230

Each

46.0000

8

8

**\*D3492-1\***

Plug

\*\*

yl 12/05/03

Location

Loc Qty

Loc Code

FP002

46

69531

8

74444

2

76235

4

77037

32

B83098

v8

D3793-1

Manufactured

No

230

Each

26.0000

1

1

**\*D3793-1\***

Wearshoe

\*\*

yl 12/05/03

Location

Loc Qty

Loc Code

FP001

26

78901

10

82171

16

yl

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 11

April-04-12 1:58:12 PM

Work Order ID: 82683

\*82683\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

56.0000

1

1

\*AN8C35A\*

BOLT

\*\*

Handwritten: 12/05/12

Location

Loc Qty

Loc Code

FP002

55

115960

1

117834

8

118286

46

ST346

1

114442

0

115188

0

115960

1

MS21083C8

Purchased

No

230

Each

115.0000

1

1

\*MS21083C8\*

NUT

\*\*

Handwritten: 12/05/12

Location

Loc Qty

Loc Code

304

50

121185

50

FP002

1

115884

1

ST303

6

115884

0

118077

1

119309

2

119436

1

119638

2

ST304

58

120142

8

120731

25

121011

25

April-04-12 1:58:12 PM

Shop Packet Print

Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April-04-12 1:58:12 PM

Work Order ID: 82683

**\*82683\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

64.0000

8

8

**\*D2745\***

Bushing

\*\*

yl 12/05/03

Location

Loc Qty

Loc Code

FP

62

1381964

40

79518

62

FP001

2

69529

1

76142

1

AN6C44A

Purchased

No

230

Each

175.0000

4

4

**\*AN6C44A\***

BOLT

\*\*

yl 12/05/03

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

173

120143

25

120465

27

120641

1

121013

20

121167

100

44

D3532-1

Manufactured

No

250

Each

55.0000

2

2

**\*D3532-1\***

Spacer

\*\*

12/5/88

Location

Loc Qty

Loc Code

ST053

55

78839

31

82041

24

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

April-04-12 1:58:12 PM

Work Order ID: 82683

\*82683\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

115.0000

2

2

\*MS21083C8\*

NUT

\*\*

1121524 JSP

Location

Loc Qty

Loc Code

304

50

121185

50

FP002

1

115884

1

ST303

6

115884

0

118077

1

119309

2

119436

1

119638

2

ST304

58

120142

8

120731

25

121011

25

NAS1149D0863J

Purchased

No

250

Each

219.0000

2

2

\*NAS1149D0863.I\*

WASHER

\*\*

1215/80 JSP

Location

Loc Qty

Loc Code

ST298

219

118078

36

119307

83

120308

100

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

April-04-12 1:58:12 PM

Page 14

Work Order ID: 82683

\*82683\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

54.0000

2

2

\*D3493-1\*

Washer

\*\*

B82023

## Location

## Loc Qty

## Loc Code

ST050

54

70697

2

77573

12

78835

40

AN8C21A

Purchased

No

250

Each

79.0000

2

2

\*AN8C21A\*

BOLT

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12/5/8

SP

## Location

## Loc Qty

## Loc Code

ST343

79

118758

5

120094

34

121067

20

121167

20

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1			D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB. POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3. BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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12/04/05

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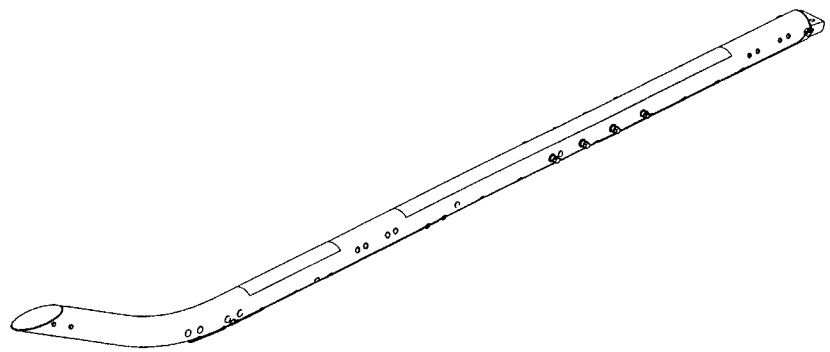
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A8-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS, ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H3L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.09
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		

DART AEROSPACE USA, INC.  
PORT HADLOCK, WA

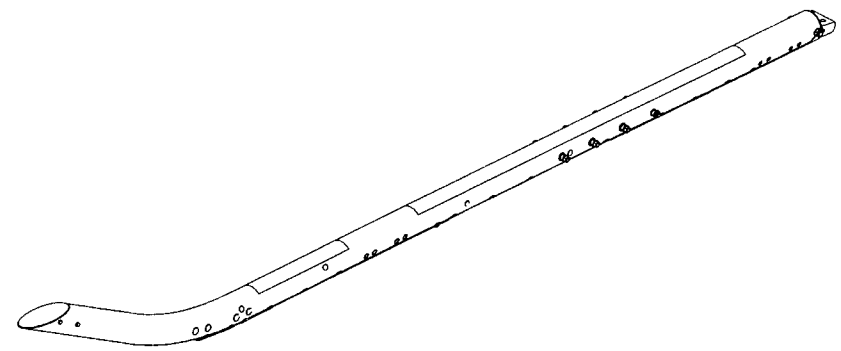
DRAWING NO. **D2750** REV. F  
SHEET 1 OF 11  
TITLE **350 SKIDTUBE ASSEMBLY** SCALE NTS

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D2750-041 350 SKIDTUBE ASSEMBLY, LH

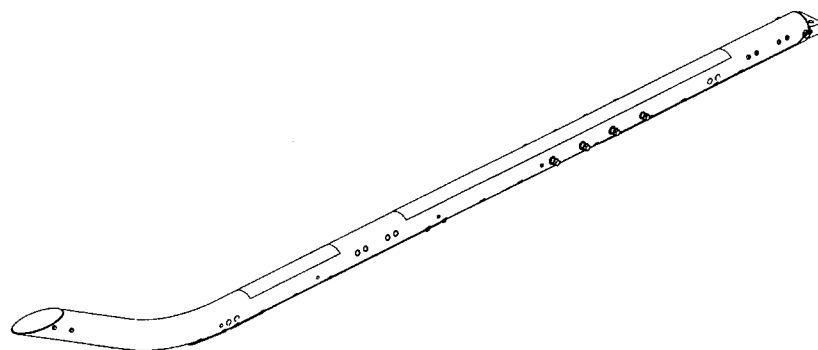


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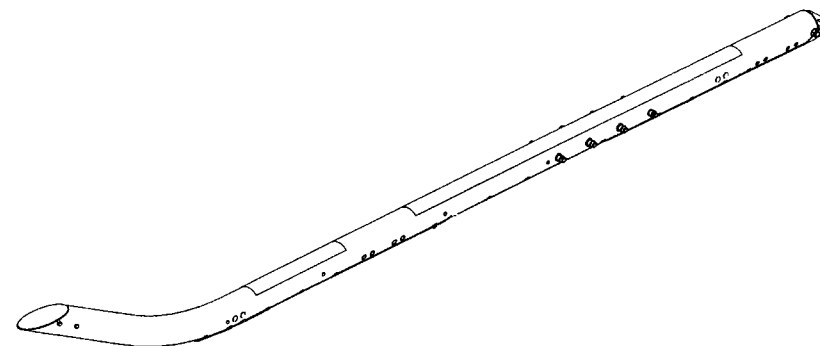
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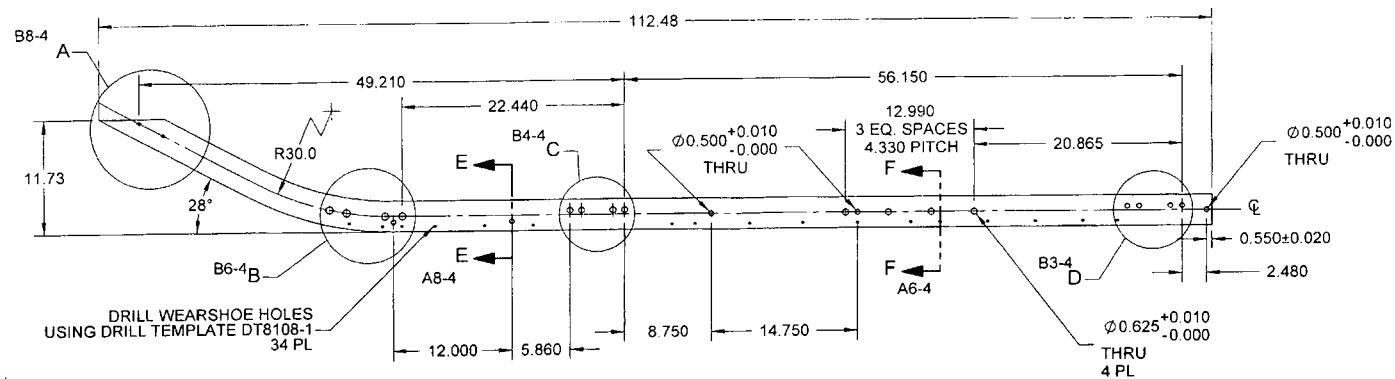
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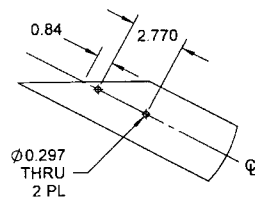
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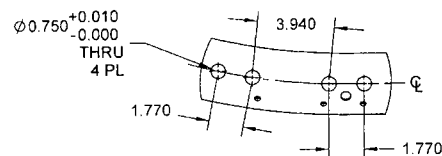
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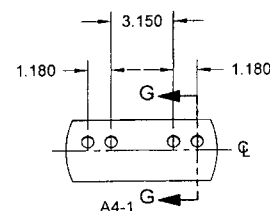
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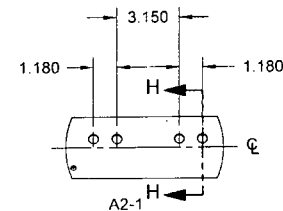
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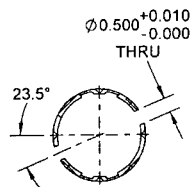
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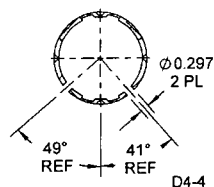
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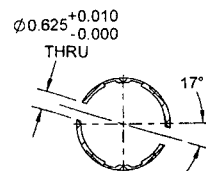
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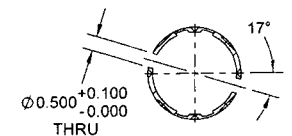
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

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PORT HADLOCK, WA

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SHEET 4 OF 11

TITLE

350 SKIDTUBE ASSEMBLY

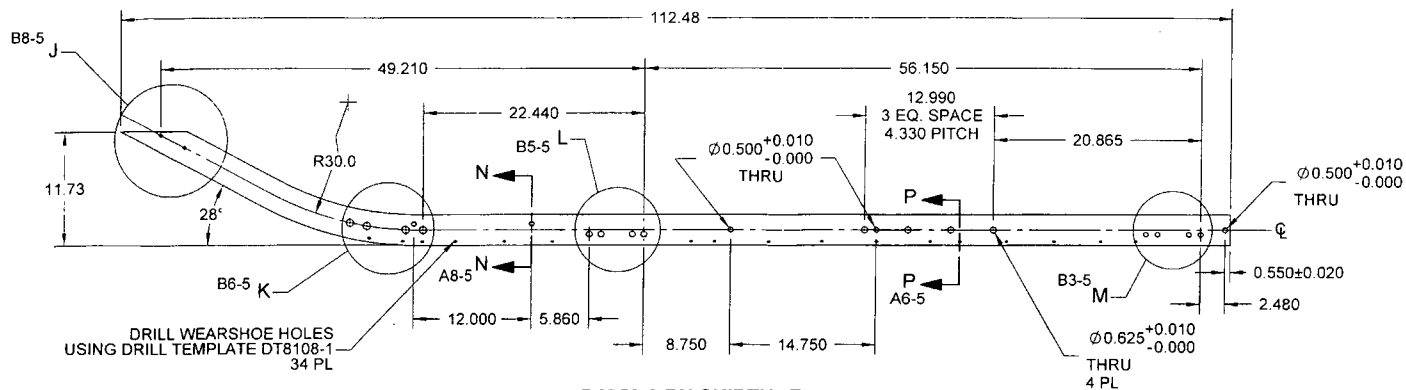
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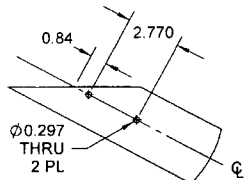
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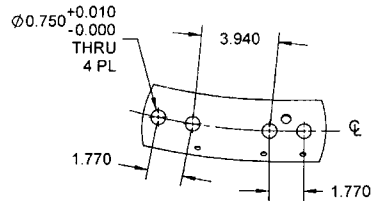
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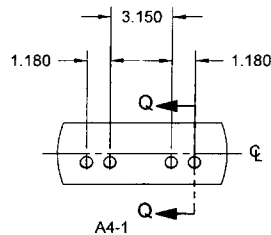
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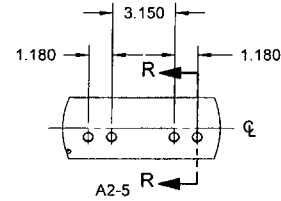
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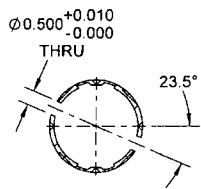
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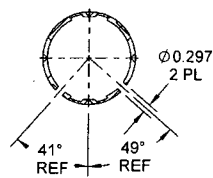
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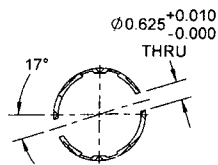
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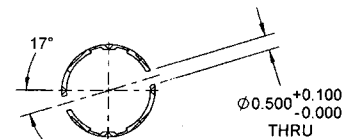
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SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



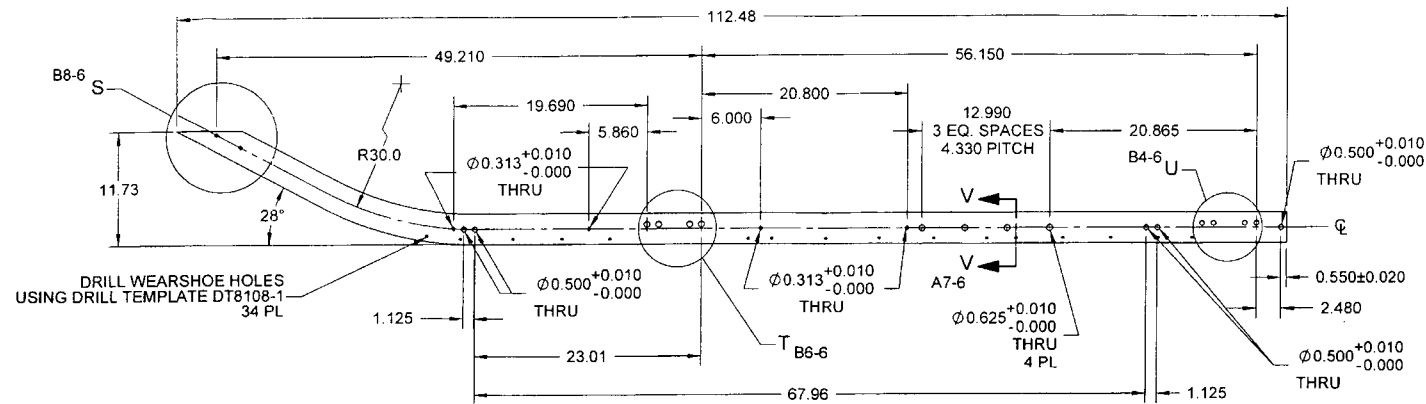
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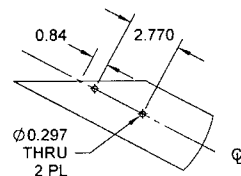
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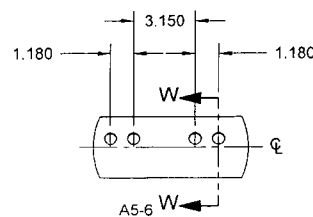
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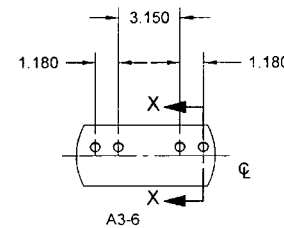
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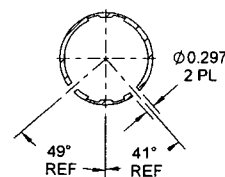
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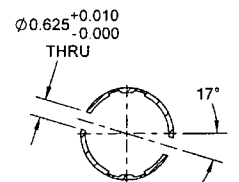
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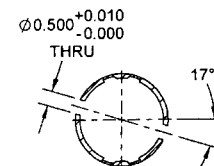
**DETAIL U**  
SCALE 2X



**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL

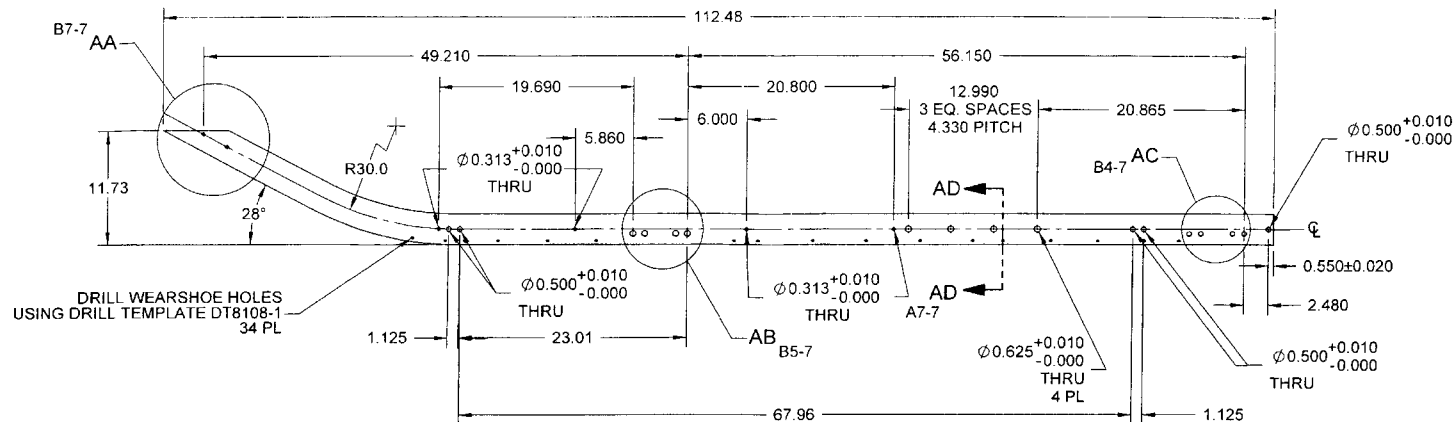


**SECTION X-X**  
SCALE 3X, 4 PL

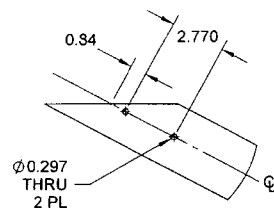
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DATE	<b>08.07.16</b>	SCALE <b>NTS</b>

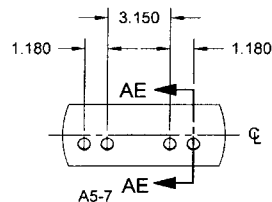
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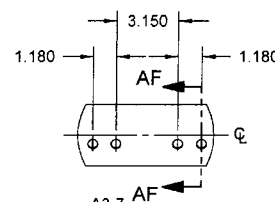
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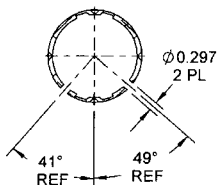
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D7-7



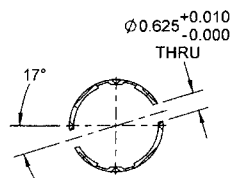
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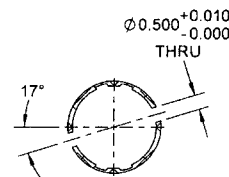
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D3-7



**SECTION AD-AD**  
SCALE 3X, 17 PL  
D3-7



**SECTION AE-AE**  
SCALE 3X, 4 PL  
B6-7

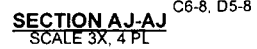


**SECTION AF-AF**  
SCALE 3X, 4 PL  
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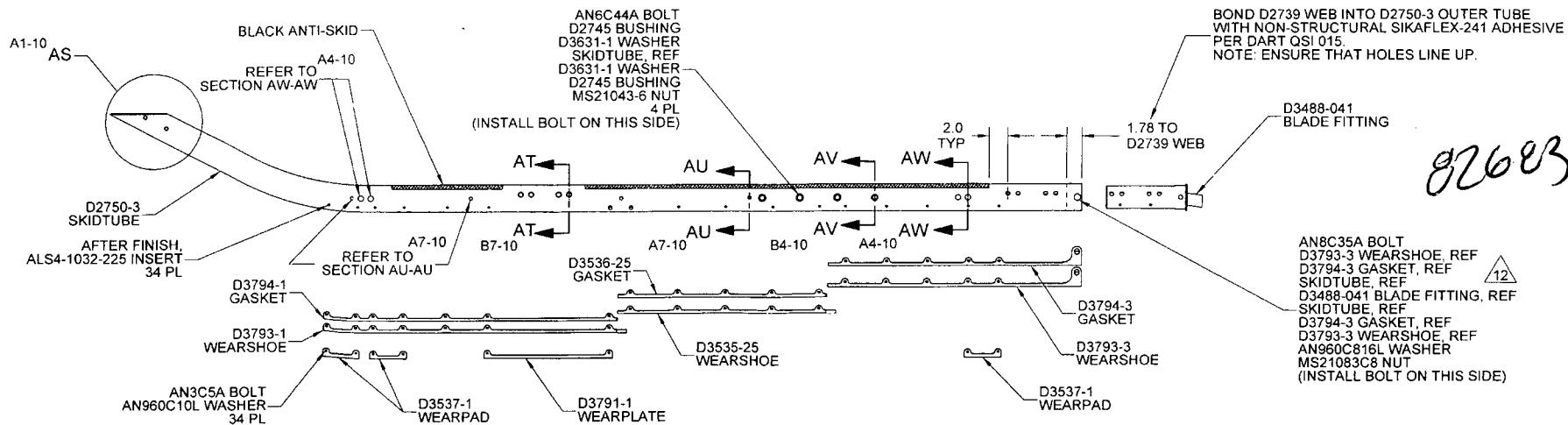
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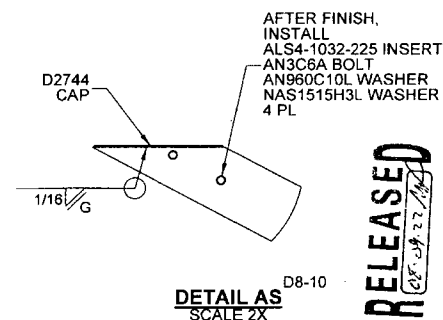
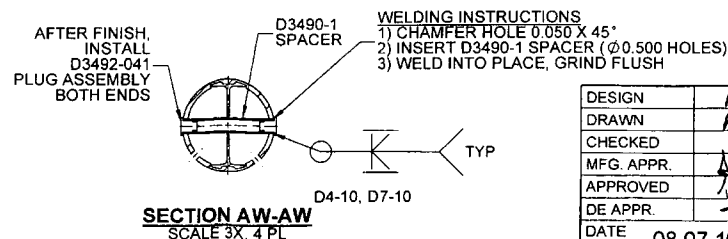
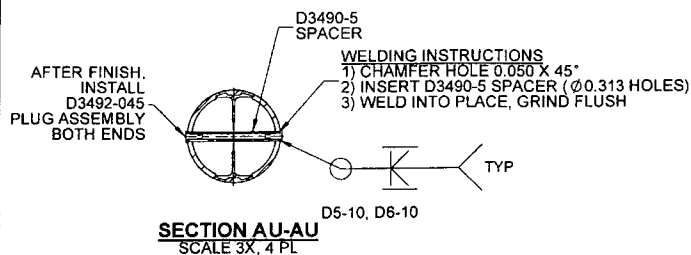
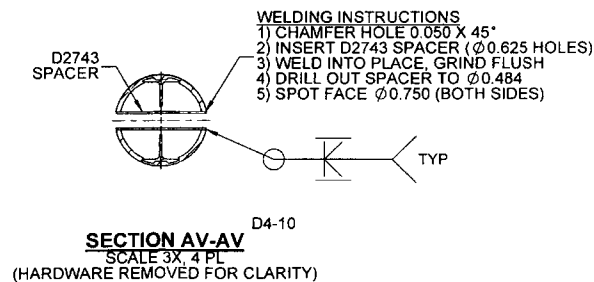
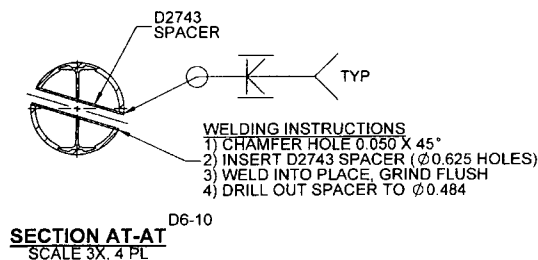
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MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	08.07.16		







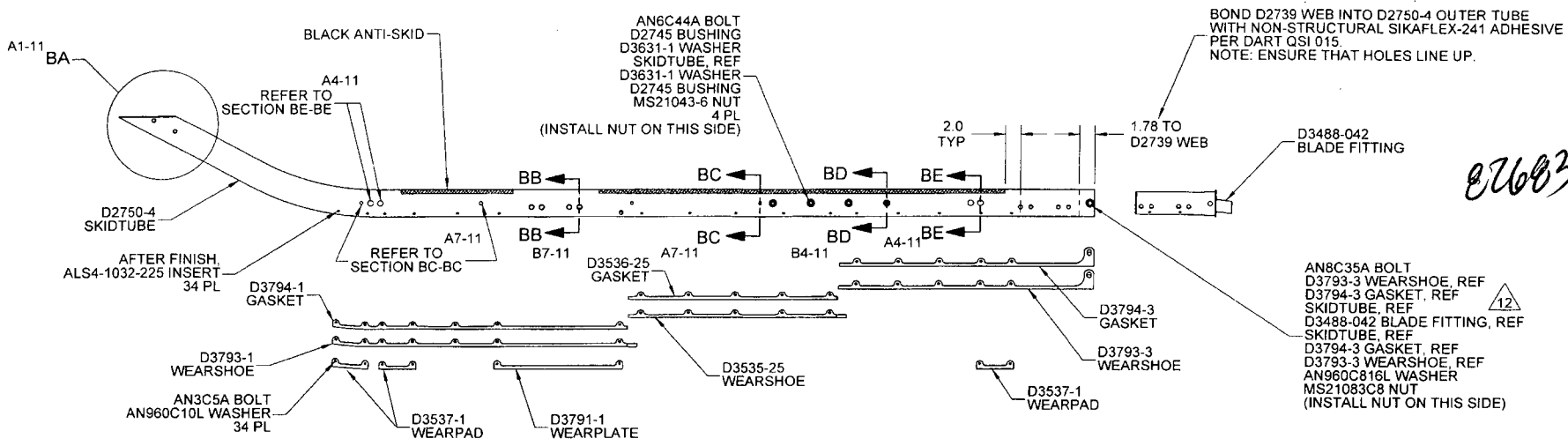
### D2750-043 350 SKIDTUBE ASSEMBLY, LH



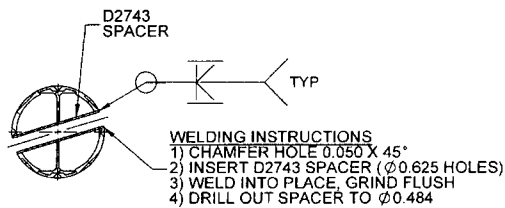
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.		TITLE	SHEET 10 OF 11
APPROVED		350 SKIDTUBE ASSEMBLY	SCALE
DE APPR.			NTS
DATE	08.07.16		

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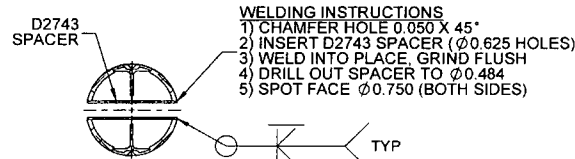
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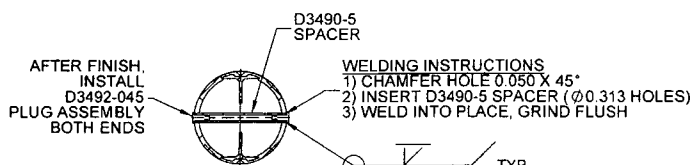
**D2750-044 350 SKIDTUBE ASSEMBLY, RH**



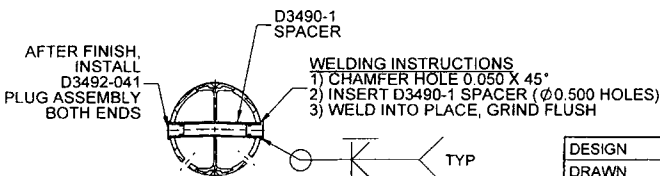
**SECTION BB-BB**  
SCALE 3X, 4 PL



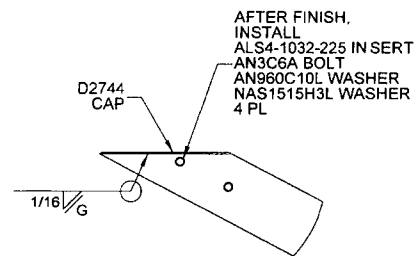
**SECTION BD-BD**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION BC-BC**  
SCALE 3X, 4 PL



**SECTION BE-BE**  
SCALE 3X, 4 PL



**DETAIL BA**  
SCALE 2X

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MFG. APPR.		D2750	SHEET 11 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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82683

8 7 6 5 4 3 2 1



NO. 293

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 82796  
Part number: A350-636-014  
Description: Skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Alum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier David Reed Date of Test Coupon 12-05-01

Welder Barclay Elliott Date of Test Coupon 12-05-01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld